

### **Amendments to the Claims**

This listing of claims replaces all prior versions, and listings, of claims in the application.

#### Listing of Claims

1. (Previously presented) A process for manufacturing a bag from a polymer and/or metal film material, comprising feeding the bag-forming material that is in a form of a single film web and that is wound up on a roll to an unwinding station of a bottom forming device, cutting the unwound film web into four film segments, connecting the four film segments to form a film tube having four outer walls that are connected respectively by four seams, and sealing the connected film segments so as to form at least one sealed end of the bag.
2. (Previously presented) The process according to claim 1, wherein the film tube includes side gussets.
3. (Previously presented) The process according to claim 1, wherein a bottom of the bag is formed by transverse sealing.
4. (Previously presented) The process according to claim 1, wherein a bottom of the bag is formed by a squeezing process and a transverse sealing process.

5. (Previously presented) The process according to claim 1, further comprising a step of filling the formed bag.

6. (Previously presented) The process according to claim 1, further comprising a step of sealing a top end of the bag by transverse sealing.

7. (Previously presented) The process according to claim 5, wherein the step of forming the bag and the step of filling the bag are performed in a form, fill, and seal machine.

8. (Previously presented) The process according to claim 1, wherein at least one part of the four seams of the film tube is formed by a joining process in which additional adhesive or extrudate joining material is applied on the seam.

9. (Canceled)

10. (Previously presented) The process according to claim 1, wherein a conveying direction of the four film segments to a joining station defines a longitudinal axis of the formed film tube.

11. (Currently amended) A tubular film roll ~~formed from~~ comprising a film tube ~~comprising~~ that includes four side walls

~~that are~~ cut from a single film web and ~~that are~~ joined to one another by four corresponding seams, each of the seams including an applied layer of extruded heated adhesive located on an edge of each of the side walls.

12. (Previously presented) The tubular film roll according to claim 11, wherein two of the four side walls have side gussets therein.

13. (Previously presented) The tubular film roll according to claim 12, wherein two front side walls of the side-gussetted film tube lie over one another.

14. (Previously presented) The tubular film roll according to claim 12, wherein the side gussets are staved toward a direction of an axis of the film tube.

15. (Withdrawn) A method of forming a bag from a polymer and/or metal film material and filling the bag, comprising feeding the bag forming material that is in a form of a single film web from a wound roll to an unwinding station of a bag forming device, cutting the unwound film web into four film segments, connecting the four film segments to form a film tube having four outer walls that are connected respectively by four seams, sealing one end of the film tube so as to form a first sealed end of the bag,

filling the formed bag, and sealing another end of the film tube so as to form a second sealed end of the filled bag.

16. (Withdrawn) The method according to claim 15, wherein the four outer walls include two opposed front walls and two opposed side walls, and further comprising a step of providing a gusset in each of the side walls.

17. (Withdrawn) The method according to claim 15, wherein the four film segments are conveyed to a joining station in which the step of connecting the four film segments is performed, and wherein a direction in which the four film segments are conveyed to the joining station defines a longitudinal axis of the formed bag.

18. (Withdrawn) The method according to claim 15, wherein a bottom of the bag is formed by a squeezing process and a transverse sealing process, and a top of the bag is formed by a transverse sealing process.

19. (Withdrawn) The method according to claim 15, wherein the seam is formed by applying an adhesive or a weld to adjacent cut film segments so as to join the segments.

20. (Withdrawn) The method according to claim 15, wherein the seam is formed by applying a heated extrudate to an edge of adjacent cut film segments so as to join the segments.

21. (Withdrawn) The method according to claim 15, wherein the four film segments are connected to form the film tube by compressing the film segments between an opposed pair of rollers.